

Ship July 14

Dart Aerospace Ltd.

Date: Thursday, 6/29/2006 3:52:27 PM  
User: Kim Johnston




# Process Sheet

<b>Customer</b>	: CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b>	: STEP WELDMENT
<b>Job Number</b>	: 27793 - <del>3</del>	<b>Part Number</b>	: D3463042
<b>Estimate Number</b>	: 10777	<b>Drawing Number</b>	: D3463 REV.B
<b>P.O. Number</b>	: N/A	<b>Project Number</b>	: N/A
<b>This Issue</b>	: 6/29/2006	<b>Drawing Revision</b>	: B
<b>Prsht Rev.</b>	: NC	<b>Material</b>	: N/A
<b>First Issue</b>	: N/A	<b>Due Date</b>	: 7/12/2006
<b>Previous Run</b>	: 27517	<b>Qty:</b>	4
<b>Written By</b>	: [Signature]	<b>Um:</b>	EACH
<b>Checked &amp; Approved By</b>	: [Signature] 060629		
<b>Comment</b>	: EST REV. A 05.11.18 new issue EC		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	238806	SS DOWEL PIN 1" LONG	
			
Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)			
Pick:			
Qty	Part Number	Description Batch	
2	238-806	SS DOWEL PIN 1" LONG M19080	PD 06-09-08 (2)
2.0	D34533	Clevis	
			
Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)			
Pick:			
Qty	Part Number	Description Batch	
1	D3453-3	Clevis B28189	PD 06-09-08 (2)
3.0	D34637	Drag Arm	
			
Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)			
Pick:			
Qty	Part Number	Description Batch	
1	D3463-7	Drag Arm B28195	PD 06-09-08 (2)
4.0	D34631	Arm	
			
Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)			
Pick:			
Qty	Part Number	Description Batch	
1	D3463-1	Arm B28192	PD 06-09-08 (2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Date: Thursday, 6/29/2006 3:52:28 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP WELDMENT

Job Number: 27793

Part Number: D3463042

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D34633

Step



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part Number	Description
1	D3463-3	Step

Batch:

B28214

PD 06-09-03 (2)

6.0

D34635

End Cap



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty	Part Number	Description
2	D3463-5	Step Flat Pattern

Batch:

B28194

PD 06-09-03 (2)

7.0

D34535

Plug



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part Number	Description
1	D3453-5	Plug

Batch:

B28190

PD 06-09-03 (2)

8.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld assembly as per dwg D3463

PD 06-09-07 (2)

9.0

QC5/9

WELD INSPECTION



Comment: WELD INSPECTION

11/06/09/08 (2)

10.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

1- Mask areas indicated on dwg D3463 (holes, threads)

2-Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

FC 06 09 11 (2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/05/12

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Date: Thursday, 6/29/2006 3:52:28 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP WELDMENT

Job Number: 27793

Part Number: D3463042

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Wing Walk as per Dwg D3463 and QSI 005 4.4

*on-m 06-09-11*

*(2)*

12.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*PO 6/9/12*

*(2)*

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

*NA*

*PO 6/9/12*

*(2)*

14.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

*PO 06/09/12*

Job Completion



*C206/09/12*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

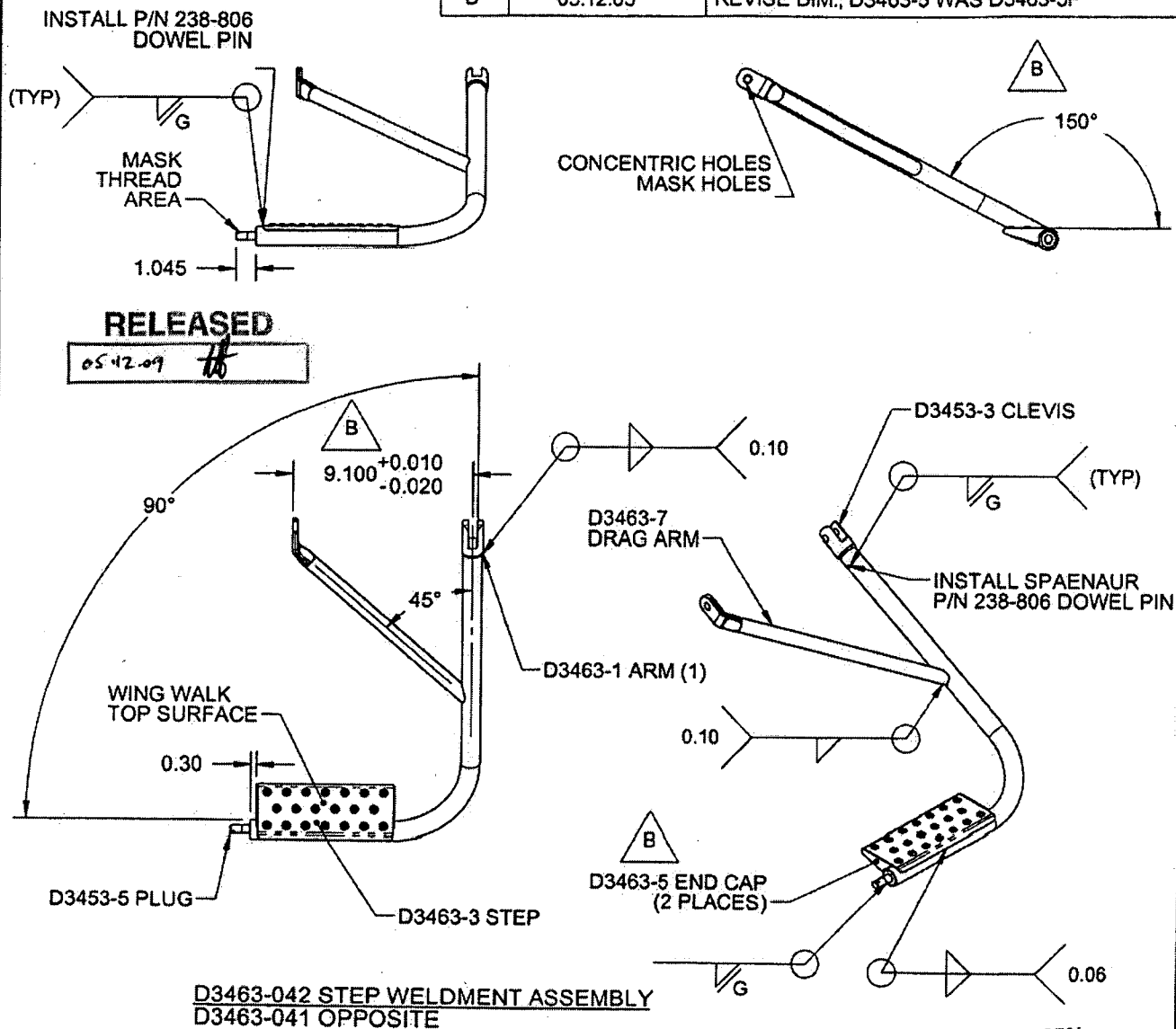
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

**DART**

DESIGN RF	DRAWN BY RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. <b>D3463</b>	REV. B SHEET 1 OF 4
DATE <b>05.12.05</b>		TITLE <b>STEP WELDMENT</b>	SCALE 1:8
A	05.09.20	NEW ISSUE	
B	05.12.05	REVISE DIM.; D3463-5 WAS D3463-5F	



**NOTES:**

- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010
- 6) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER

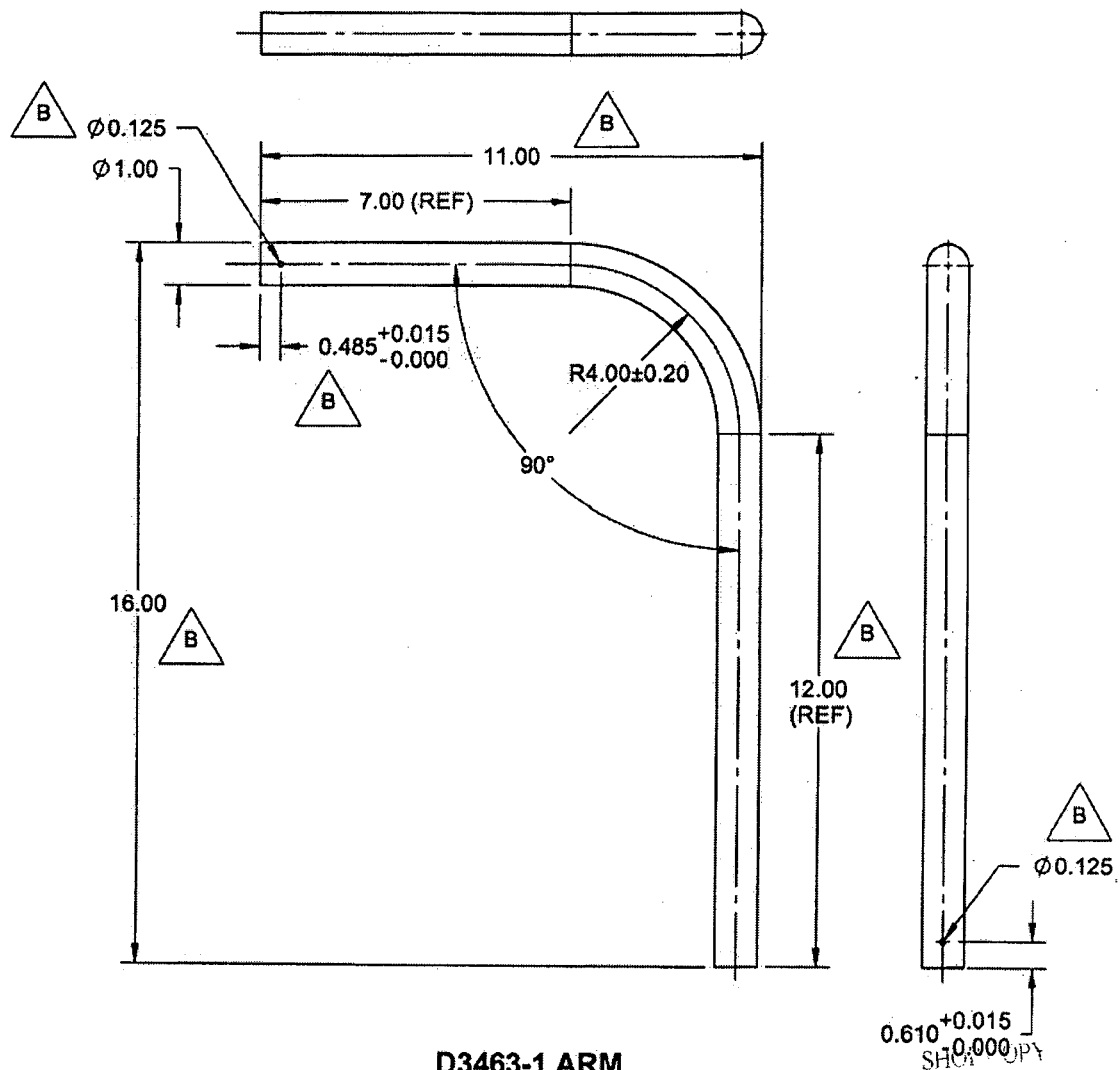
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CHECKED 	APPROVED 	DRAWING NO. <b>D3463</b>	REV. B SHEET 2 OF 4
DATE <b>05.12.05</b>		TITLE <b>STEP WELDMENT</b>	SCALE 1:4

05.12.09



**D3463-1 ARM**

**NOTES:**

- 1) MATERIAL: AISI 316/304 SS SEAMLESS TUBING (REF. DART SPEC. M304TR-0000W120)  
2) FINISH: NONE  
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
4) ALL DIMENSIONS ARE IN INCHES  
5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.025

0.610 +0.015  
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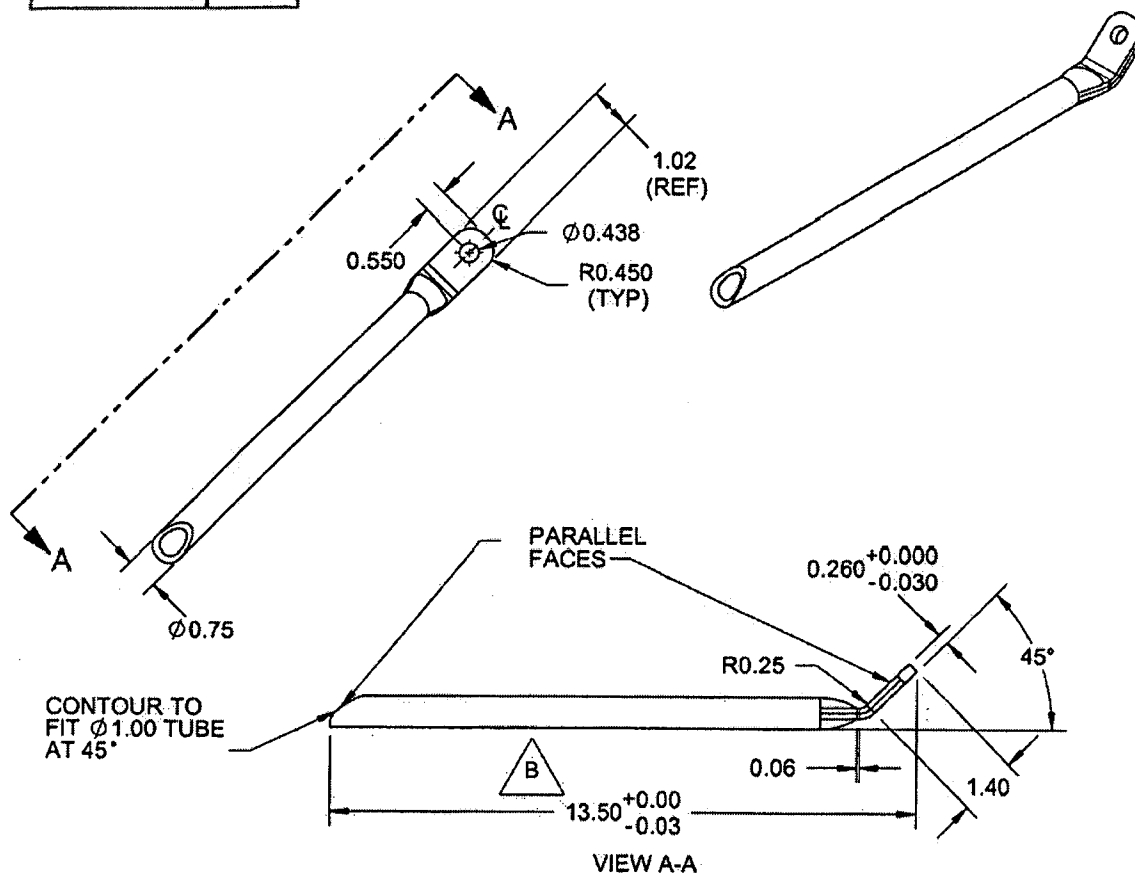


**DART**

DESIGN RF	DRAWN BY RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3463	REV. B SHEET 3 OF 4
DATE 05.12.05	TITLE STEP WELDMENT		SCALE 1:4

**RELEASED**

05.12.09 #

**D3463-7 DRAG ARM****NOTES:**

- 1) MATERIAL: AISI 316/304 SS SEAMLESS TUBING (REF. DART SPEC. M304TR0.750W-120)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010

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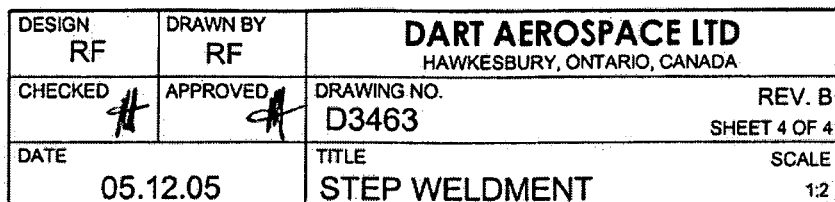
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WORK ORDER

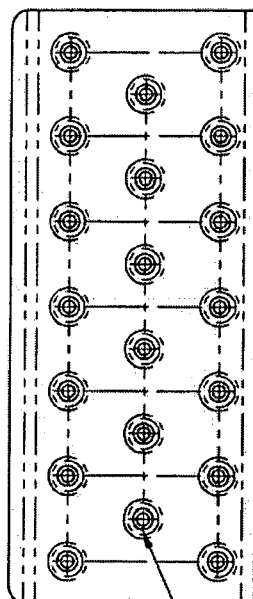
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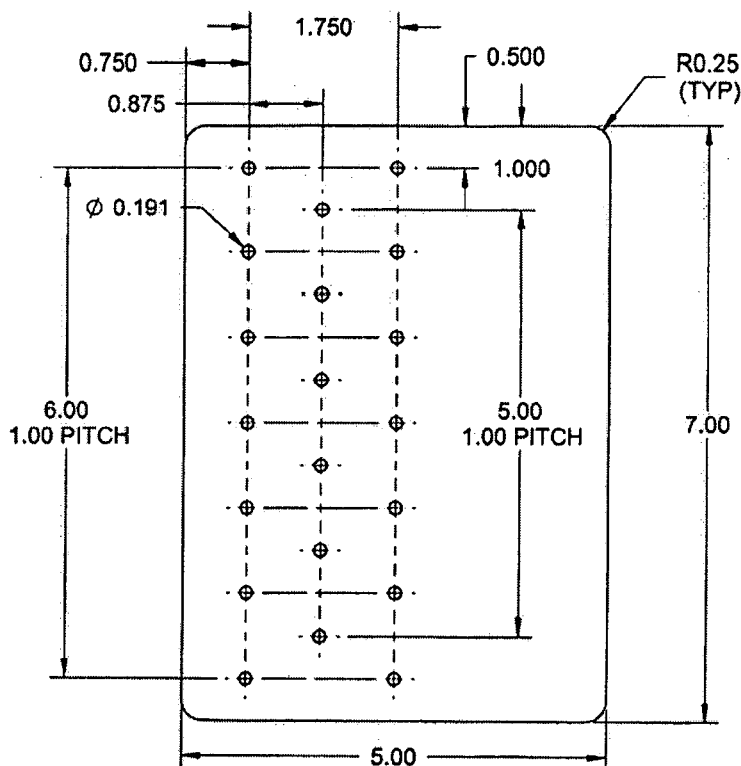
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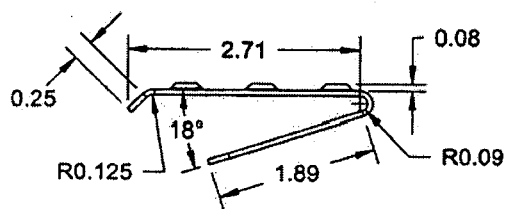
05.12.09



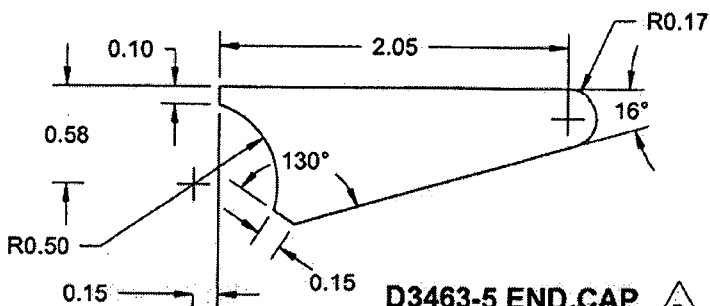
FORM USING  
D3463-3T1



**D3463-3F FLAT PATTERN**



### D3463-3 STEP



**D3463-5 END CAP**

**SCALE 1:**

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M304S16GA) AMENDMENT

WITHOUT NOTICE

WORK ORDER

NO. 2775

**NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET, 0.060 THICK (REF. DART SPEC.)  
2) FINISH: NONE  
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
4) ALL DIMENSIONS ARE IN INCHES  
5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010

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